Dart Aerospace Ltd. Monday. 28/07/2008 3:38:57 PM Date: User: Lind# Lacelle **Process Sheet** : LONG T-HANDLE ASSEMBLY : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer : 40770 Job Number : 13522 **Estimate Number** : PB674300151 Part Number P.O. Number - B6743001 P.13 : 28/07/2008 S.O. No. : **Drawing Number** This Issue : N/A . Prsht Rev. : NC Project Number : B1 : 11 : SMALL /MED FAB First Issue Type **Drawing Revision** Material **Previous Run** : 04/08/2008 **Due Date** Written By Checked & Approved By Comment : Est Rev:A 08-07-25 new issue DD verified by:ec See attachment **Additional Product** Job Number: **Description:** Seq. #: Machine Or Operation: PB674300187 1.0 Tube Arm Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Tube Arm 2.0 Comment: Qty.: 1:0000 Each(s)/Unit 5.0000 Each(s) Total: Tube Handle batch: // 3.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Tube End Cap 40074 batch: LARGE FABRICATION RESOURCE 1 4.0 Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 hefore

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Page 1

Each

Date: Monday, 28/07/2008 3:38:57 PM User: Linda Lacelle **Process Sheet** Drawing Name: LONG T-HANDLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 40770 Part Number: PB674300151 Job Number: Seq. #: Description: Machine Or Operation: QC9 VISUAL WELDING INSPECTION 6.0 Comment: VISUAL WELDING INSPECTION PB674300189 7.0 Clevis Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) 8.0 SPRING SLOTTED PIN Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) SPRING SLOTTED PIN batch: M11 850 SMALL & MEDIUM FAB RESOURCE 1 9.0 Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin INSPECT WORK TO CURRENT STEP 10.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 11.0% POWDER COATING 02316 Comment: POWDER COATING Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 QC3 08-0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Date:

Monday, 28/07/2008 3:38:57 PM

User:

Linda Lacelle

Customer CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 40770

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

PACKAGING RESOURCE #1

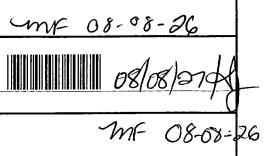
Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 101

14.0

QC21

FINAL INSPECTION/W/O RELEASE

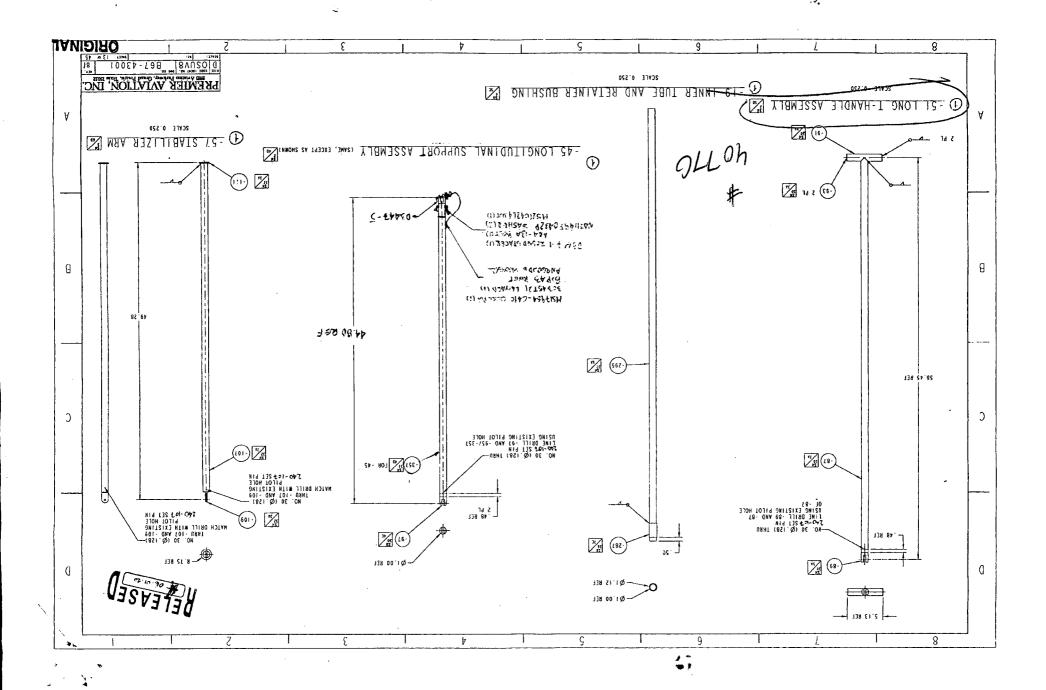


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

1 "





DART AEROSPACE LTD	Work Order:	39952
Description: LONG T-HANDLE ASSY	Part Number:	B67-43001-51
Dwg: B67-43009 Sheet 13	Qty:	1:
owg. 1564: 4760:		Page of

Qty eq 3 .03 .010
93
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010
10
1.
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Rev	Date	Change	Revised By	Approved
				72